

Date: Thursday, 5/4/2006 11:14:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EYEBALL ADAPTER
Job Number : 26959	
Estimate Number : 12246	
P.O. Number : N/A	Part Number : D3480041
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3480 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26599	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 5/28/2006 Qty: <u>4</u> Um: Each
Checked & Approved By : <u>06/05/05</u>	
Comment : est rev. A 06/02/07 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34805	EYEBALL ADAPTER FLANGE
-----	--------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-5	Flange	B 27001

2.0	D34803	tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-3	Tube	B 27000

SB 06/05/18 (4)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot weld as per dwg D3480

2-Cut tube flush as per dwg D3480

3-Deburr

SB 06/05/18 (4)

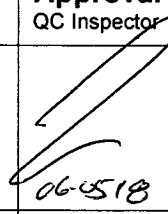
4.0	QC511	WELD INSPECTION
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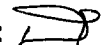


Comment: WELD INSPECTION

06/05/18 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	4	QC Sd II for spot weld permanent change					 06-05-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/05/18
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:14:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 26959

Part Number: D3480041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: ST413

AP 06/05/18 (4)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AP 06/05/19 (4)

Job Completion



U 06.05.19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

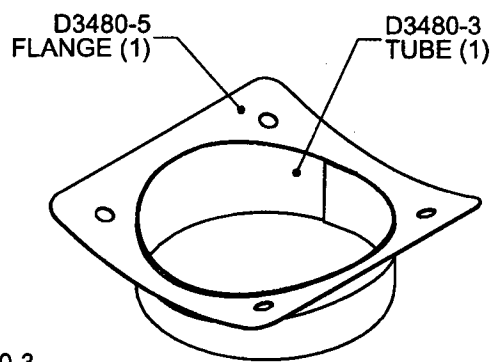
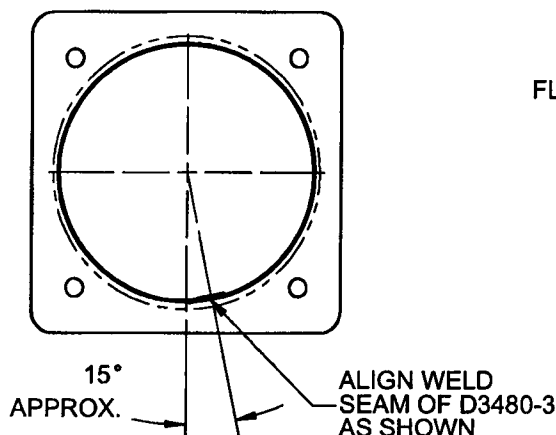
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

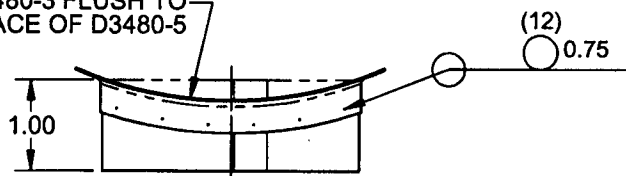
NOTE: Date & initial all entries

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DATE 06.02.06		TITLE EYEBALL ADAPTER SCALE 1:2	
A	06.02.06	NEW ISSUE	

~~06.04.03~~

SPOT WELD PARTS, THEN
CUT D3480-3 FLUSH TO
SURFACE OF D3480-5

**D3480-041 EYEBALL INLET ADAPTER**

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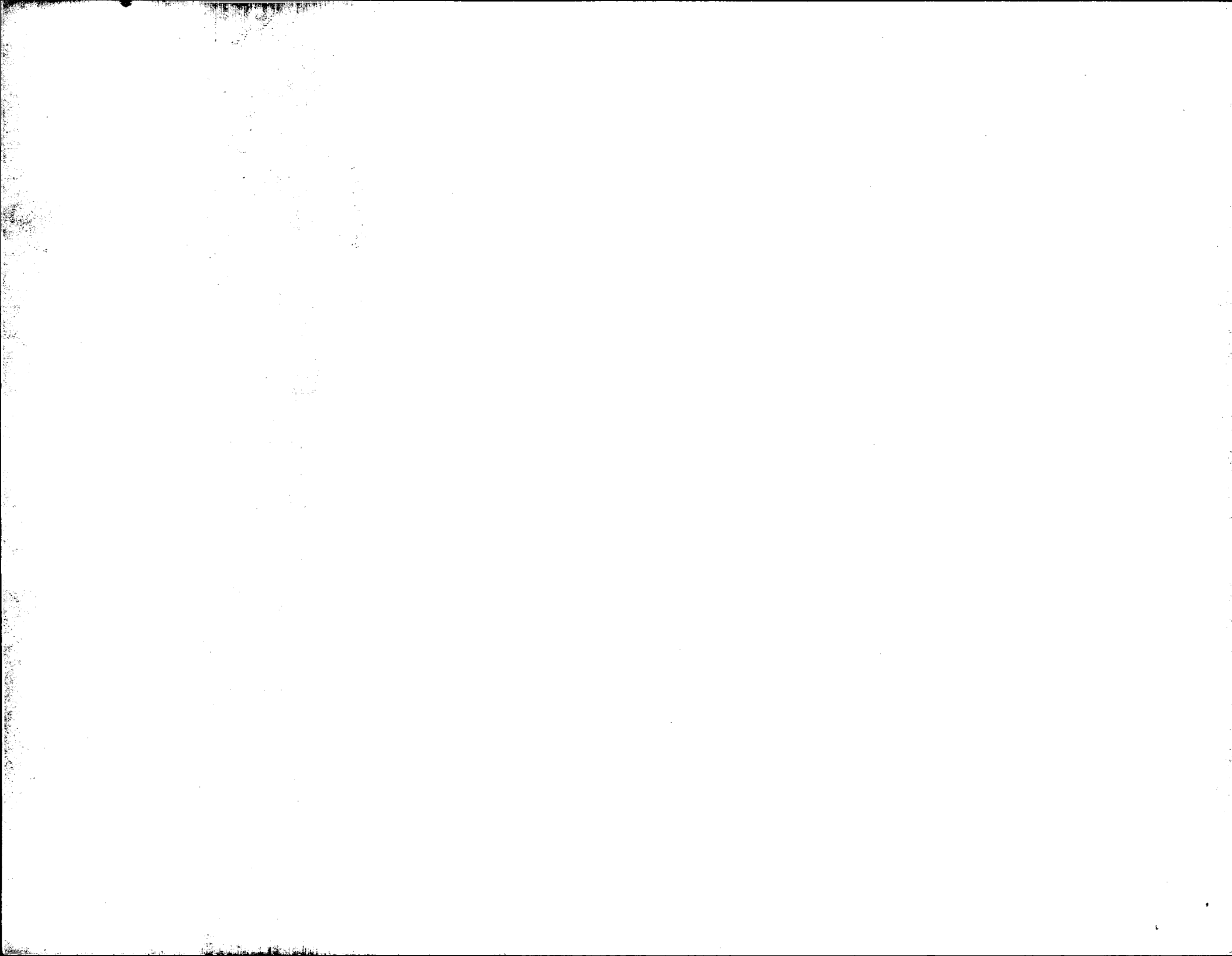
NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

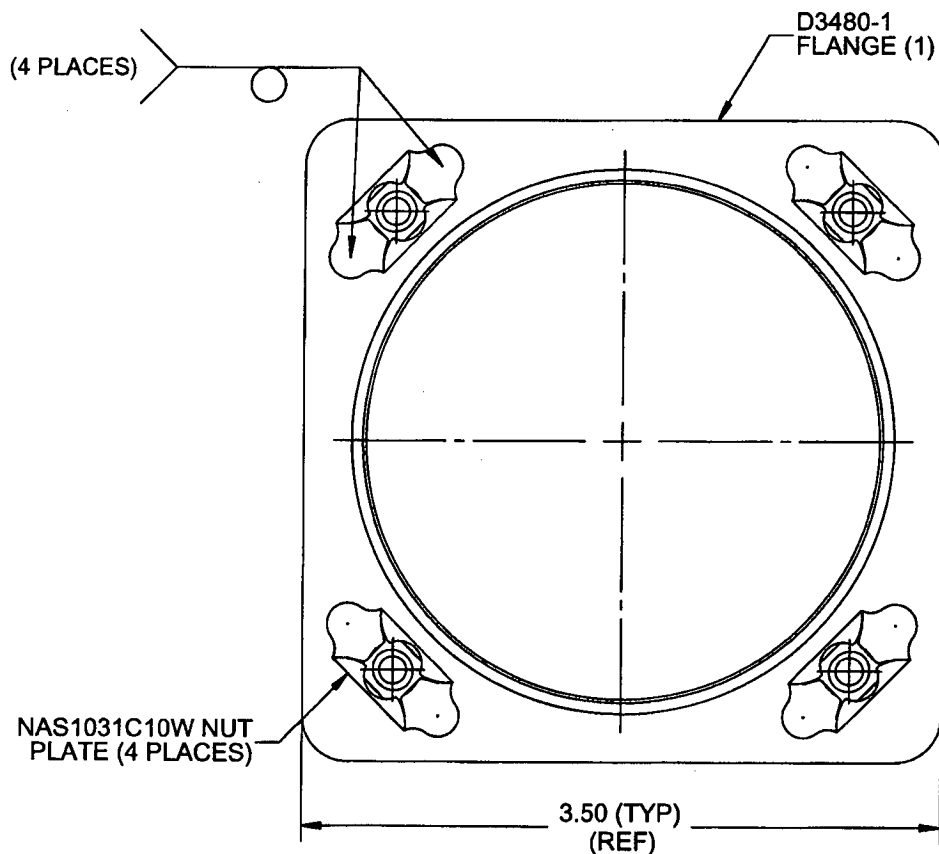
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:1



D3480-043 EYEBALL ADAPTER

NOTES:

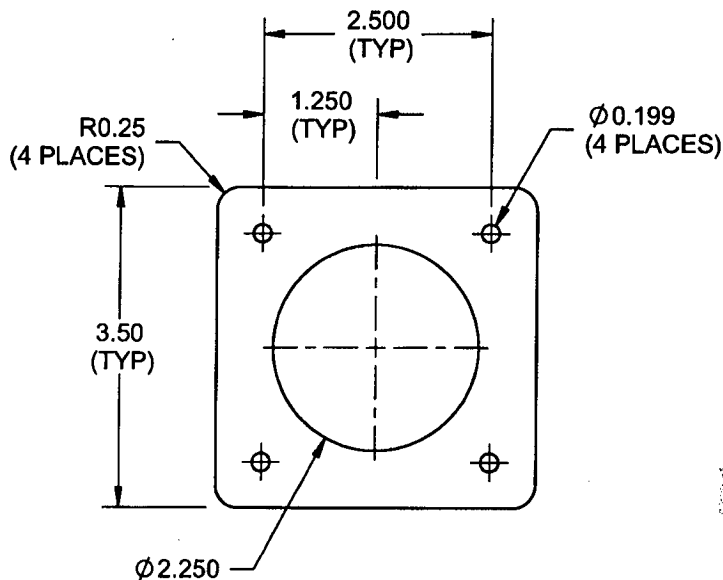
- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

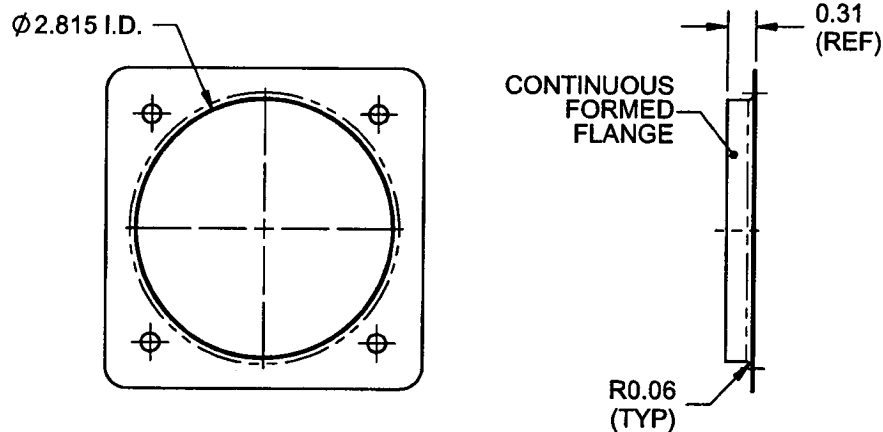
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



D3480-1F FLAT PATTERN



D3480-1 FLANGE (MAKE FROM D3480-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

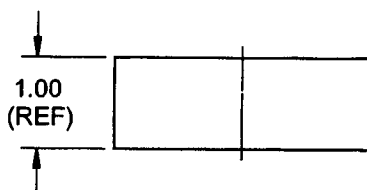
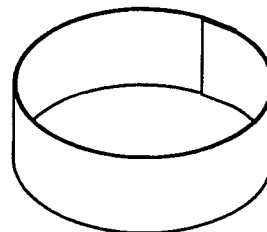
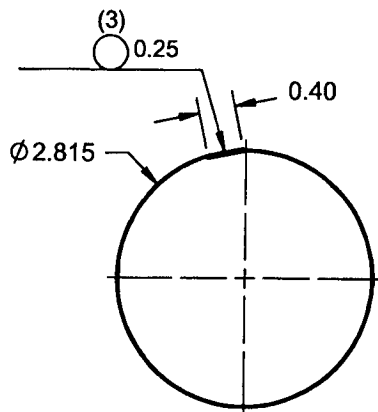
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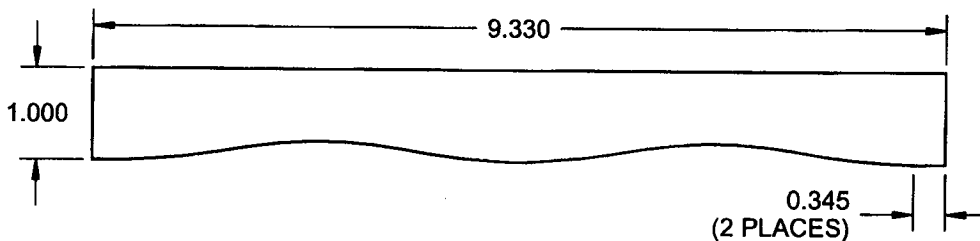


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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



D3480-3 TUBE

[Handwritten: #6403]



D3480-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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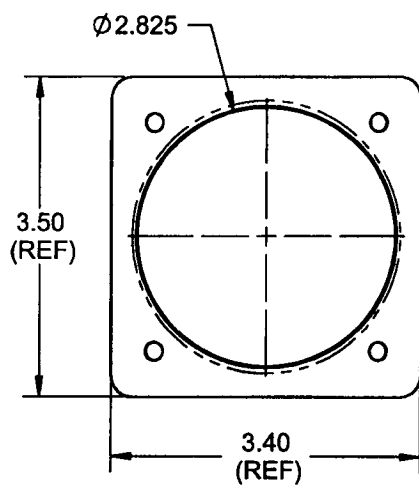
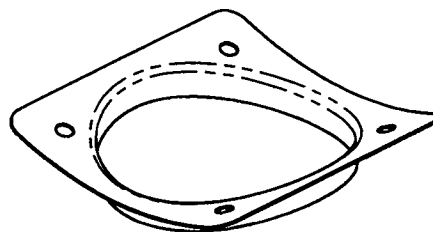
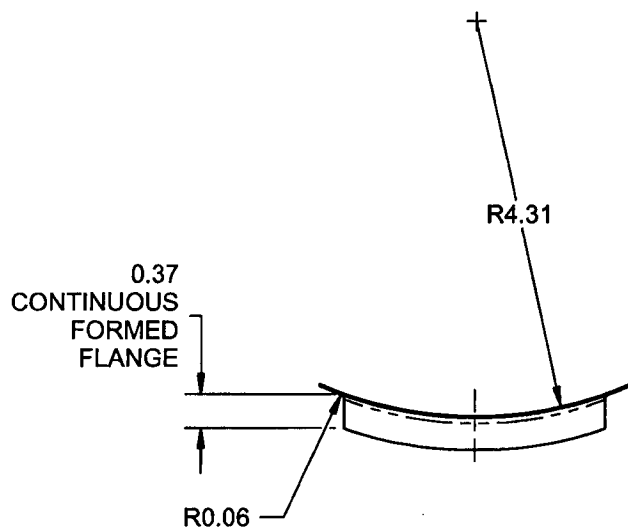
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



[Handwritten signature] 06.04.03

D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

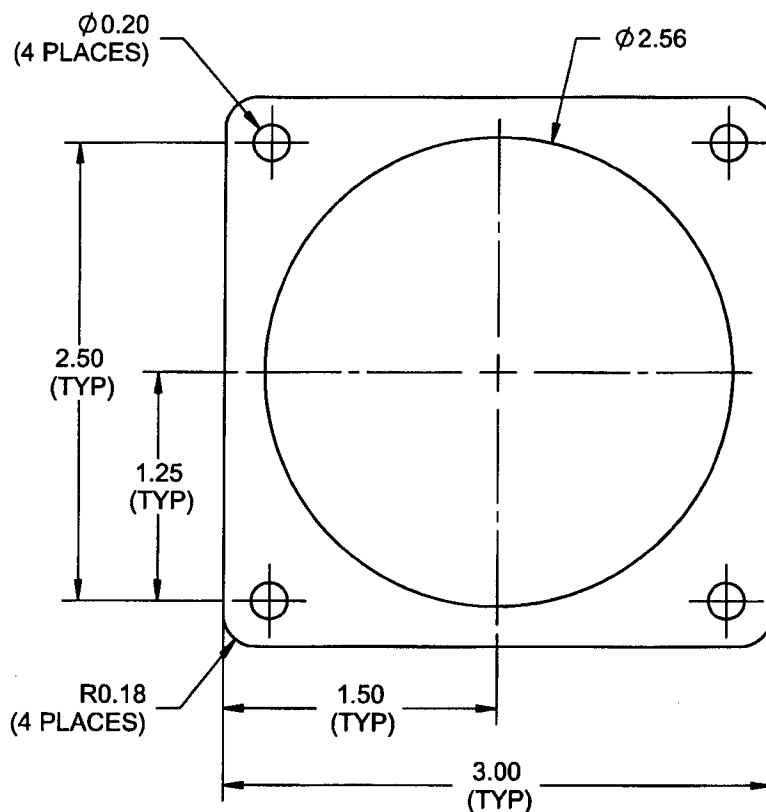
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:1



[Signature] 06.04.03

D3480-7 GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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